



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D206-642-341
Job Sheet 195717



Part No: D206-642-341

Job Qty: 1 pcs

Part Name: Replacement Skidtube (Fits LH or RH)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Due Date: 7/5/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG REV F(DEO) IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DS19440 rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC ver: DD IPP Rev: L 12.11.22 now swage per ecn12-679 DD ver: JLM IPP Rev: M 14.04.25 ECN14-520 DD ver: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	7/5/19		0.00	3.23	Skidtubes - 1		ON
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
115	QC 5	1 pcs	7/5/19		0.00	0.00	QC 5 - 10		JUN 26 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
116	QC 9	1 pcs	7/5/19		0.00	0.00	QC 9 - 10		JUN 26 2019
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		



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CANADA
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Container No: S194277



Part: D206-642-341

Job No: 195717

Serial No/Batch: S194277

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SA00475SE 18/10/17, 18/12/18, 18/12/19, 18/12/20, 18/12/21, 18/12/22, 18/12/23, 18/12/24, 18/12/25, 18/12/26, 18/12/27, 18/12/28, 18/12/29, 18/12/30, 18/12/31, 19/01/01, 19/01/02, 19/01/03, 19/01/04, 19/01/05, 19/01/06, 19/01/07, 19/01/08, 19/01/09, 19/01/10, 19/01/11, 19/01/12, 19/01/13, 19/01/14, 19/01/15, 19/01/16, 19/01/17, 19/01/18, 19/01/19, 19/01/20, 19/01/21, 19/01/22, 19/01/23, 19/01/24, 19/01/25, 19/01/26, 19/01/27, 19/01/28, 19/01/29, 19/01/30, 19/01/31, 19/02/01, 19/02/02, 19/02/03, 19/02/04, 19/02/05, 19/02/06, 19/02/07, 19/02/08, 19/02/09, 19/02/10, 19/02/11, 19/02/12, 19/02/13, 19/02/14, 19/02/15, 19/02/16, 19/02/17, 19/02/18, 19/02/19, 19/02/20, 19/02/21, 19/02/22, 19/02/23, 19/02/24, 19/02/25, 19/02/26, 19/02/27, 19/02/28, 19/02/29, 19/02/30, 19/03/01, 19/03/02, 19/03/03, 19/03/04, 19/03/05, 19/03/06, 19/03/07, 19/03/08, 19/03/09, 19/03/10, 19/03/11, 19/03/12, 19/03/13, 19/03/14, 19/03/15, 19/03/16, 19/03/17, 19/03/18, 19/03/19, 19/03/20, 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120 Handfinish - 1-1 Chemical- B4B	1 pcs	7/5/19	0.00 0.50	QC 9 - 9	
				Handfinish - 1 - 1 - B4B	BF819-06-28
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
Handfinish - 1 - 22 - B4B					
125 QC 7	1 pcs	7/5/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	MGA
				QC 7 - 9	
QC 7 - 68					
QC 7 - 50					
QC 7 - 67					
				Plex 5/30/19 9:08 AM Dart.Guerin.Kimberley	

5/30/2019

[Dart Hawkesbury] Job Sheet - Guerin, Kimberley

130 Skidtubes - 2 - B4B	1 pcs	7/5/19	0.00 3.23	QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				Skidtubes - 1 - B4B	DD
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
140 QC 5	1 pcs	7/5/19	0.00 0.00	Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
150 Skidtubes - 3 - B4B	1 pcs	7/5/19	0.00 3.23	QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
180 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Skidtubes - 1 - B4B	
190 Handfinish - 2-1 Pressure- B4B	1 pcs	7/5/19	0.00 0.50	Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				QC 5 - 10	
200 Powdercoat - 1 White Gl(A)- B4B	1 pcs	7/5/19	0.00 0.23	QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
190 Handfinish - 2-1 Pressure- B4B	1 pcs	7/5/19	0.00 0.50	QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
200 Powdercoat - 1 White Gl(A)- B4B	1 pcs	7/5/19	0.00 0.23	QC 5 - 30	
				QC 5 - 40	
				Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
				Powdercoat - 1 - B4B	
200 Powdercoat - 1 White Gl(A)- B4B	1 pcs	7/5/19	0.00 0.23	Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	

DAS
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JUL 19 2019

JUL 19 7:23

5/30/2019

[Dart Hawkesbury] Job Sheet - Guerin, Kimberley

DAS
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9-89

210 QC 3	1 pcs	7/5/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	19-7-21
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
220 Handfinish - 4-1-Assembly-B4B	1 pcs	7/5/19	0.00 5.00	Handfinish - 4 - 1 - B4B	19-7-21
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
230 QC 3	1 pcs	7/5/19	0.00 0.00	Handfinish - 4 - 9 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	

DAS
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9-89

JUL 26 2019

Plex 5/30/19 9:08 AM Dart.Guerin.Kimberley

[Dart Hawkesbury] Job Sheet - Guerin, Kimberley

				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
240 QC 5	1	7/5/19	0.00 0.00	QC 5 - 10	
	pcs			QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
250 Packaging 3-1 - Stock - B4B	1	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs			Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
255 DC - 1 - B4B	1	7/5/19	0.00 0.00	DC - 1 - B4B	
	pcs			DC - 2 - B4B	
260 QC 21 - FG	1	7/5/19	0.00 0.00	QC 21 - FG - 21	

DAS
40
9-89

JUL 26 2019

DAS
28
9-89

AUG 02 2019

AUG 02 2019

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pcs	QC 21 - FG - 70	QC 21 - FG - 53
Part Op 110 - Skid tubes - 1-Deburr Fwd edge of tube 2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650 A/R 5-Cut Descriptions: aft end to length as per dwg D2650 6-Drill pilot holes using drill Jig DT8168A (A, & B) and DT8025. 7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297". 8-Open Aft Cap Hole using #6 Drill Bit 9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail 10-Remove inner indexing ridge on aft end of skid tubes as per Dwg D2650 11- Ream holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid) 12-Deburr. 115 - QC5- Inspect part completeness to step on W/O 116 - QC9- Inspect visual per QSI004- Fusion Welds 120 - Chemical Conversion Coat per QSI005 4.1 125 - QC7-Inspect Chemical Conversion Coat 130 - Skid tubes 1- Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting 140 - QC5- Inspect part completeness to step on W/O 150 - Skid tubes - 1- Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002 2- Install nut plate as per dwg 180 - QC5- Inspect part completeness to step on W/O 190 - Pressure Wash per QSI005 4.3/ Clean and remove all markings 200 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. START TIME: _____ FINISH TIME: _____ 210 - QC3- Inspect Part Finish 220 - HandFinish4 (Assemble as per dwg - 1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. 2- Apply RTV 598 on the plugs Batch: <u>519 536.3</u> 230 - QC3- Inspect Part Finish 240 - QC5- Inspect part completeness to step on W/O 250 - Identify and pack for shipping as per PPP D206-642-341 Location:FG107 255 - Document Control - Photocopy bluefile and create labels per PPP D206-642-341 CHG005 260 - QC21- Final Inspection - Work Order Release - 7 -Wing Walk as per Dwg D2650-5 and QSI 005 4.4		

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2620	Skid tube, 206 Skid tube	1 pcs (1 ea)	110-Skid tubes - 1	5189572
D2647	Cap	1 pcs (1 ea)	110-Skid tubes - 1	5166098
D2654-5	Web	1 pcs (1 ea)	130-Skid tubes - 2 - B4B	5175899
D4720-1	Spacer	19 pcs (19 ea)	150-Skid tubes - 3 - B4B	5178089
ALS4-1032-130	Rivnut	54 Ea (54 ea)	220-Handfinish - 4-1-Assembly-B4B	5057257
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	220-Handfinish - 4-1-Assembly-B4B	FM137622
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	220-Handfinish - 4-1-Assembly-B4B	FM137886-0
D2646	Aft Cap	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B	5160607
D2651-1	Plug	14 pcs (14 ea)	220-Handfinish - 4-1-Assembly-B4B	5167951
D2651-3	O-Ring	14 pcs (14 ea)	220-Handfinish - 4-1-Assembly-B4B	5027453
D2680-041	Nut Plate	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B	5177216
D3537-1	Wearpad	6 pcs (6 ea)	220-Handfinish - 4-1-Assembly-B4B	5195622
D3537-3	Wearpad	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B	5185624
D4956-11	Wearplate Fwd	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B	5179847
D4956-23	Wearplate Center Fwd	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B	5171523
D4956-35	Wearplate Aft	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B	5172571
MS27039-1-08	Screw	2 Ea (2 ea)	220-Handfinish - 4-1-Assembly-B4B	5186797
MS27039-4-06	Screw	1 Ea (1 ea)	220-Handfinish - 4-1-Assembly-B4B	5166974-1
MS27039C1-08	Screw	54 Ea (54 ea)	220-Handfinish - 4-1-Assembly-B4B	5167302
NAS1149C0332R	Washer	54 Ea (54 ea)	220-Handfinish - 4-1-Assembly-B4B	5158079
NAS1149D0332J	Washer	2 Ea (2 ea)	220-Handfinish - 4-1-Assembly-B4B	5178372
NAS1149D0463J	Washer	1 Ea (1 ea)	220-Handfinish - 4-1-Assembly-B4B	5055957

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2620	1	4	0
	D2647	1	43	0
130-Skidtubes - 2 - B4B	D2654-5	1	11	0
150-Skidtubes - 3 - B4B	D4720-1	19	222	0
220-Handfinish - 4-1-Assembly-B4B	ALS4-1032-130	54	7,594	0
	CCR264SS3-3	2	159	0
	CR3212-4-03	2	84	0
	D2646	1	33	0
	D2651-1	14	95	0
	D2651-3	14	304	0
	D2680-041	1	11	0
	D3537-1	6	68	0
	D3537-3	1	18	0
	D4956-11	1	9	0
	D4956-23	1	10	0
	D4956-35	1	8	0
	MS27039-1-08	2	467	0
	MS27039-4-06	1	95	0
	MS27039C1-08	54	477	0
	NAS1149C0332R	54	3,404	0
	NAS1149D0332J	2	3,596	0
	NAS1149D0463J	1	3,447	0
Part Specifications				
Specifications could not be found.				

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QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

F

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DEO ATTACHED

RELEASED
08-07-23

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	08.03.30
D	REDRAW; INCCRP. DE09136/9153/9183 MOD GROUND HANDLING ON D2650-1A3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.08.08		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

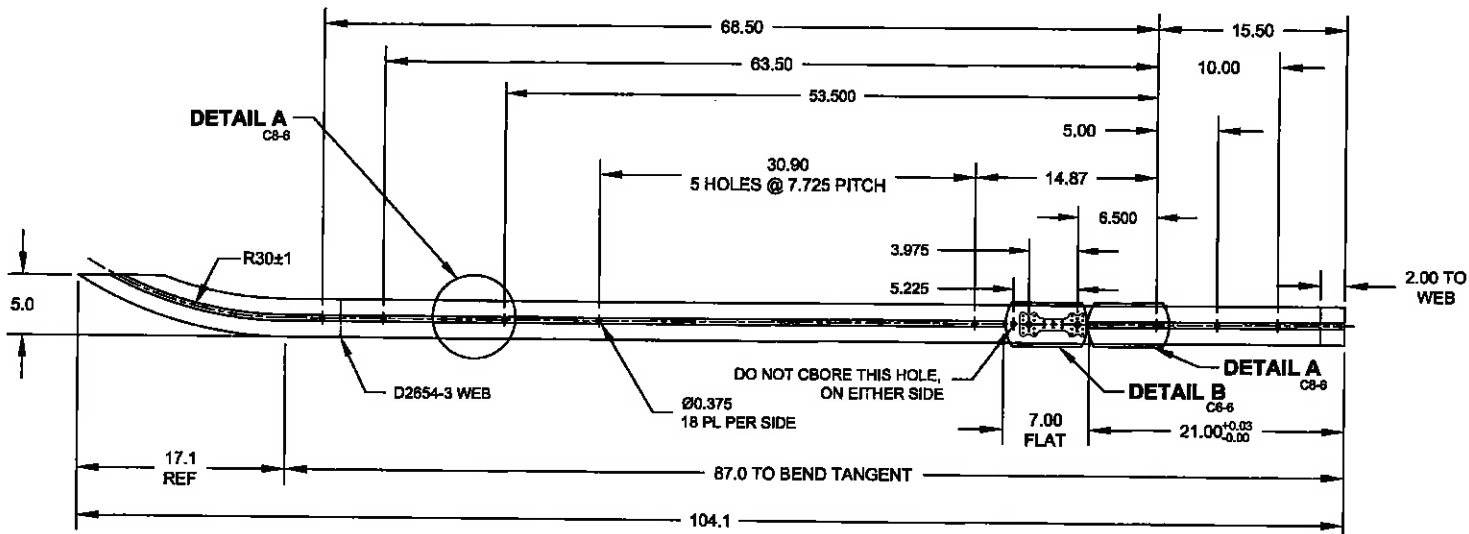
DRAWING NO. REV. F
D2650 SHEET 1 OF 6
TITLE SCALE
206/407 SKIDTUBE ASSEMBLIES NTS

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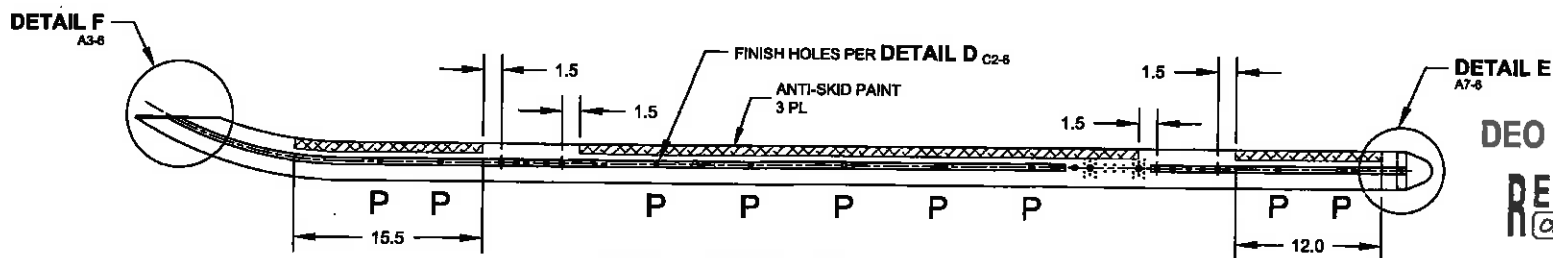


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880922/114

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DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D2650	SHEET 2 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206/407 SKIDTUBE ASSEMBLIES	NTS
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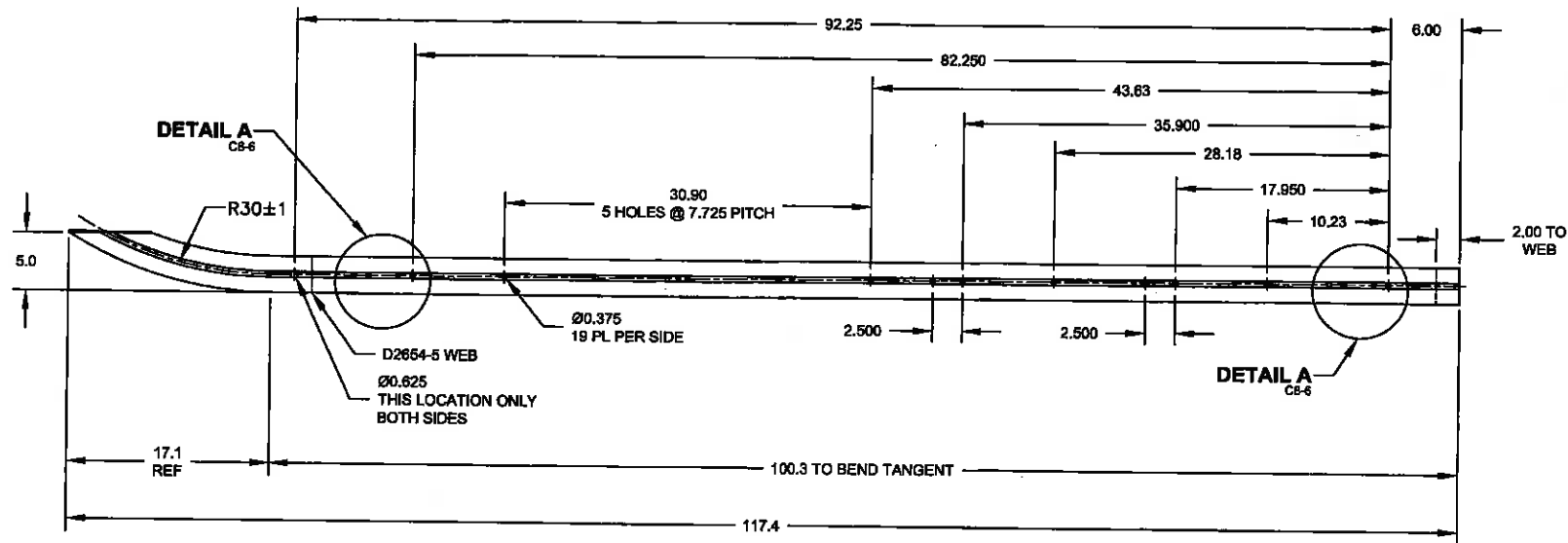
D2650-3 BENDING/DRILLING DETAIL



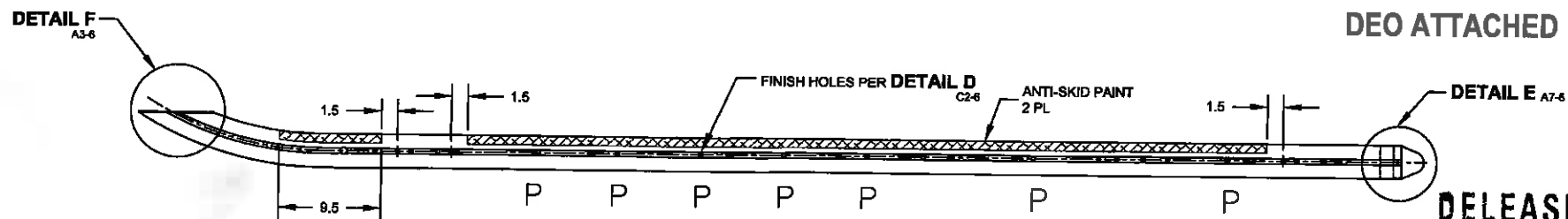
D2650-3 ASSEMBLY/FINISHING DETAIL

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08-07-02

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MFG. APPR.		D2650	SHEET 3 OF 6
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D2650-5 BENDING/DRILLING DETAIL

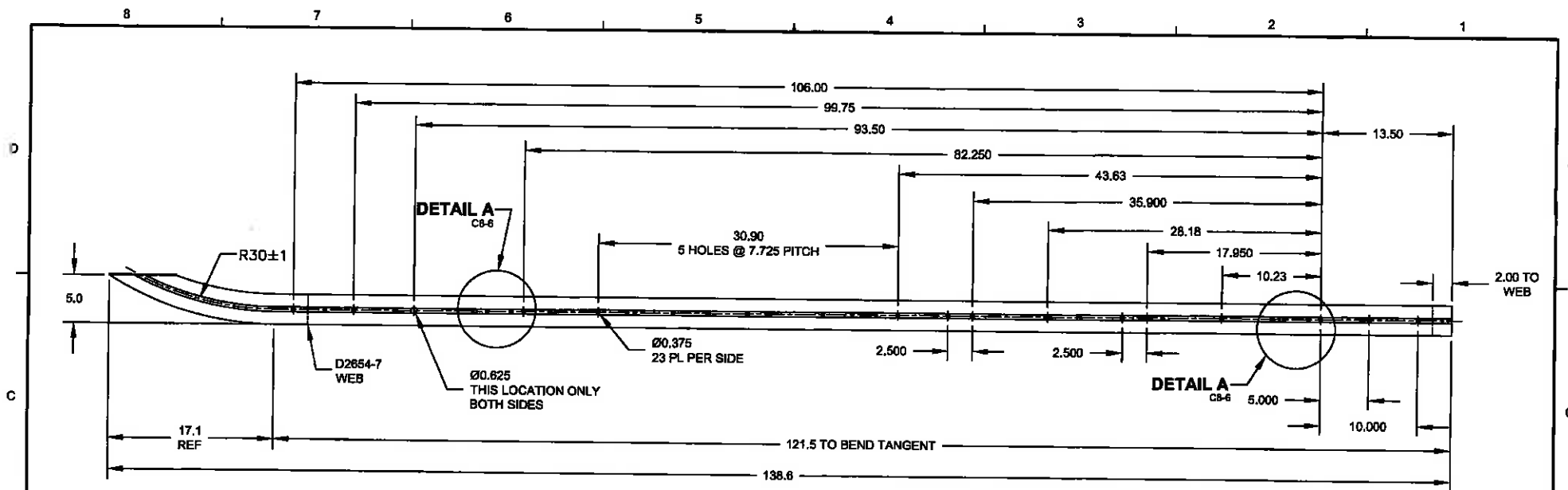


D2650-5 ASSEMBLY/FINISHING DETAIL

DEO ATTACHED

RELEASED
10/22/10

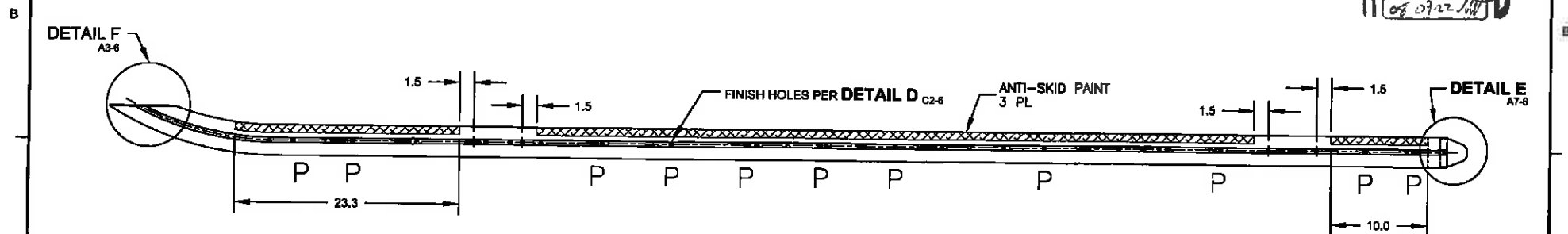
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DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	B	D2650	SHEET 4 OF 6
APPROVED	AP	TITLE	SCALE
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D2650-7 BENDING/DRILL DETAIL

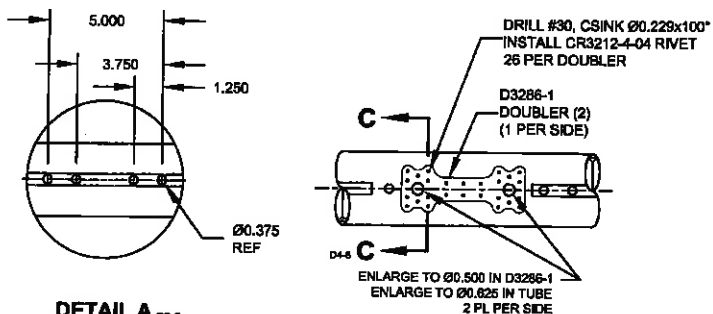
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RELEASED
07/22/00



D2650-7 ASSEMBLY/FINISHING DETAIL

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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 5 OF 6
APPROVED		TITLE	SCALE
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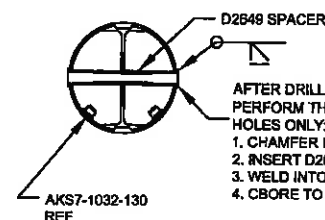
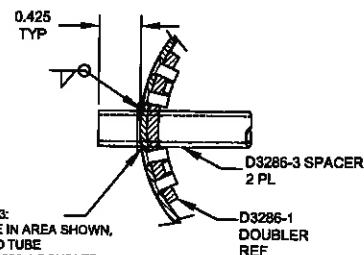
DETAIL A C2-2
SCALE 2X D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D8-6

DETAIL B C3-2
SCALE 2X C3-3

- TO INSTALL D3286-1-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.

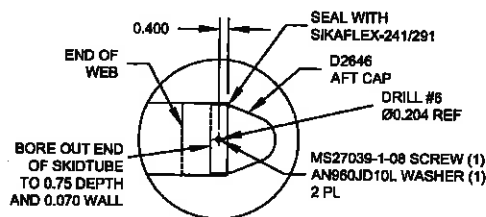


SECTION C-C C7-6
SCALE NONE

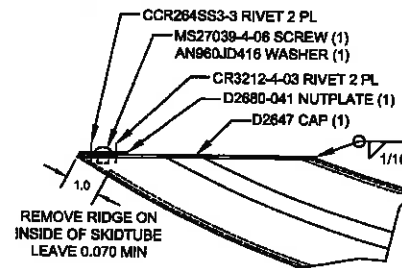
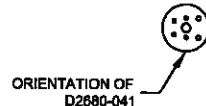


DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X

B4-2
B4-3
B4-4
B4-5



DETAIL E B2-2
SCALE 2X B2-3
B1-4
B1-6



DETAIL F B8-2
SCALE NONE B8-3
B8-4
B8-5

DETAIL F NOTES:

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR
TO FINISH

RELEASED

DEO ATTACHED

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
APPROVED		TITLE	SCALE
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DRAWING NO. D2650	TITLE 206/407 SKIDTUBE ASSEMBLIES	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2650-F-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>AP</i>	CHECKED A.P.	MFG. APPR. <i>DA</i>	APPROVED <i>#</i>		DE APPR. <i>#</i>		
DATE 12.10.12	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22		DATE 12.10.22		

PURPOSE:

CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

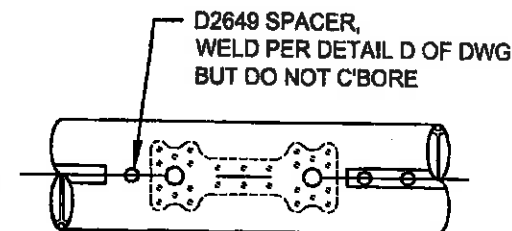
IS:

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
1	1	0	0	D2649	CROSS BOLT SPACER
16	17	19	23	D4720-1	SPACER

WAS:

17	18	19	23	D2649	CROSS BOLT SPACER
----	----	----	----	-------	-------------------

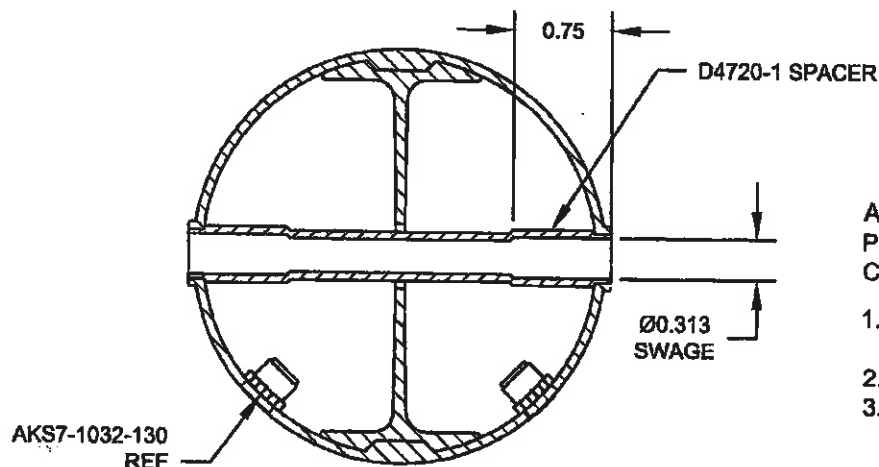
ADD DETAIL G BELOW, WHICH IS THE SAME SECTION VIEW AS DETAIL D OF DWG.
C'BORED HOLES ARE NOW SWAGED PER DETAIL G BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER DETAIL D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).



DETAIL B

AMENDMENT TO DETAIL B
NOT TO SCALE

RELEASED
2012-11-16
MP



DETAIL G

FOR Ø0.375 HOLES ONLY
FOR HOLES THAT ARE CURRENTLY C'BORED ONLY
NOT TO SCALE

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 16 PL (-1) OR 17 PL (-3)
OR 19 PL (-5) OR 23 PL (-7)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002



Quotation

PHGE Machine Works LLC dba
Arrow Tech Machine Works
29751 E. Enid Rd. Unit C
Eugene, Oregon 97402

Date	Quote #
5/30/2019	304

Phc (541) 780-6938
FA (458) 215-4938
Em atechmachineworks@gmail.com

Customer Details	Payment Terms	Sales Rep
Dart Aerospace	Withing 30 days due net	Gabriel Escobar
Contact		
Patrick Lussier		

Qty	Item	Description	Unit Price	Amount
1	RB6795966	PULLERT KIT	\$ 5,992.00	\$ 5,992.00
1	RB6798984	ADAPTER FRONT AND REAR GEAR HOUSING	\$ 1,443.50	\$ 1,443.50
1	RB6887819	FIXTURE CHECKING GAS PRODUCER	\$ 2,556.00	\$ 2,556.00

Thank You

Subtotal	\$ 9,991.50
Freight	
Payment and Credit Applied	
Total	\$ 9,991.50

Entered: 2h Date: Oct '51/19



NCR No. 9-7682

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

Job: <u>195717</u> Part No. <u>D206-642-341</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☒ Water Jet ☐ Supplier ☐ Quality ☐			
Date :		Sequence #:		QTY Affected :		MRB (QSI042) INSP 12 <u>9/19/25</u>	
Description Work Order Deviation				Disposition			
Ø 0.625 Hole too small for tow lug.				Drill the Ø0.625 towing lug hole to Ø0.640 (ref. D3274 Rev. G)			
				Completed By <u>JW 19-07-03</u> Lead hand / Supervisor <u>JW 19-07-03</u> QC / QA Coordinator <u>40 9-89</u> <u>JUL 19 2019</u>			
Root Cause		FAULT CATEGORY					
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☒ Human Factors ☐		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☒ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
		Other/Details:					